

Date: Tuesday, 11/6/2007 1:25:44 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARSHOE
Job Number :	35562		
Estimate Number :	12737		
P.O. Number :	N/A	Part Number :	D353513
This Issue :	11/6/2007	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3535 REV B
First Issue :	N/A	Project Number :	N/A
Previous Run :	34316	Drawing Revision :	B
		Material :	N/A
		Due Date :	11/20/2007
Written By :	Qty:		30 Um: Each
Checked & Approved By :	<u>07 11 07</u>		
Comment :	Est Rev: A New Issue 07-02-15 JLM Est Rev: B As per Rev B 07-08-31 JLM Verified By: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.8930 sf(s)/Unit Total : 26.7908 sf(s)
 304/316 .040 Sheet

(M304S20GA)

Batch:

22.325
 106027 1B 07-11-13

105841 xS = 4.465

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev:

B

1B 07-11-13

Prog Rev:

B

2-Deburr if necessary

1B 07-11-13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D3535 using Jig DT8158 Identify as D3535-13

EB

07/11/19 (30)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 21/12/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/6/2007 1:25:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 35562

Part Number: D353513

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



conts

Comment: INSPECT WORK TO CURRENT STEP

calulus (x30)

7.0

POWDER COATING

POWDER COATING



M105642



(30x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

m.f 07/11/20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(30)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

pf 07-11-21

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(30x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

F-P 16

m.f 07/11/21

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

07/11/21

Job Completion



u 07-11-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

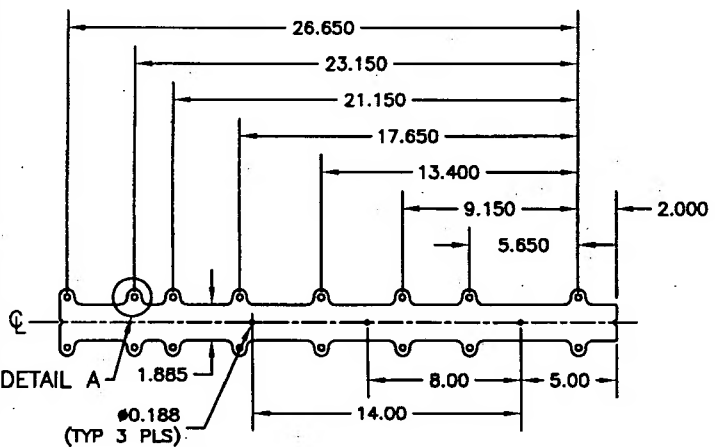
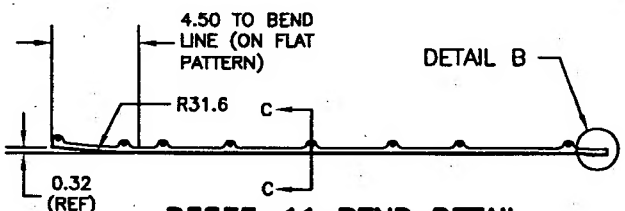
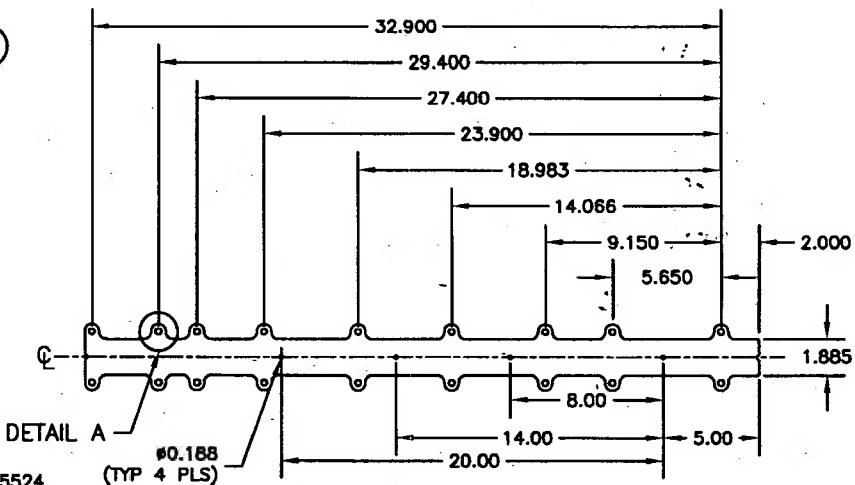
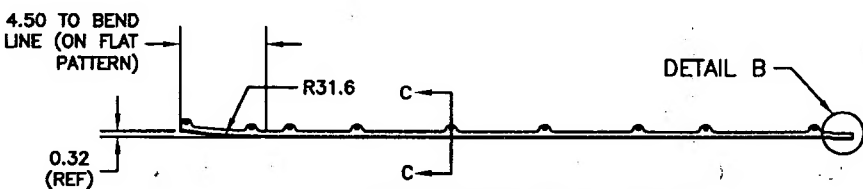
NOTE: Date & initial all entries

DART

RELEASED

07.04.24

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CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 1 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

SHOP COPY
RETURN TO
ENGINEERING
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WITHOUT NOTICE
WORK ORDER
NO. 353562

NOTES

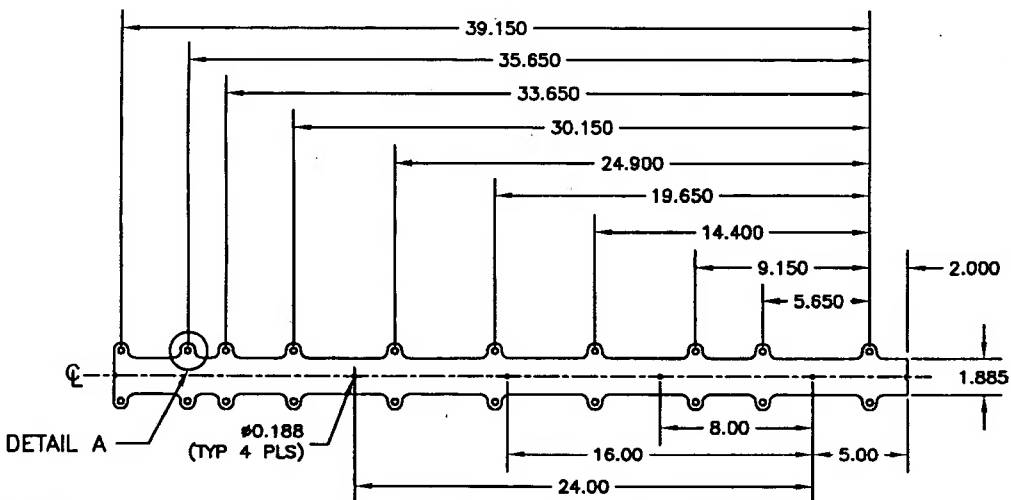
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DART

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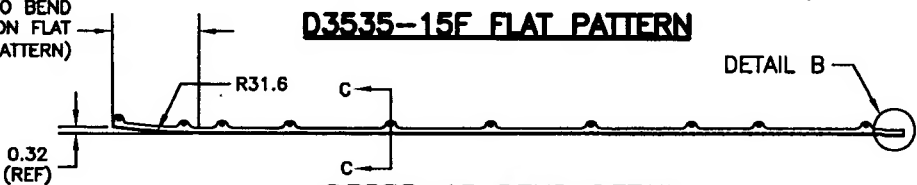
07.04.24

DESIGN	C.B.	DRAWN BY	A.H.	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	TITLE	WEARSHOE	REV. B
		DRAWING NO.	D3535	SHEET 2 OF 7
		SCALE	1:10	

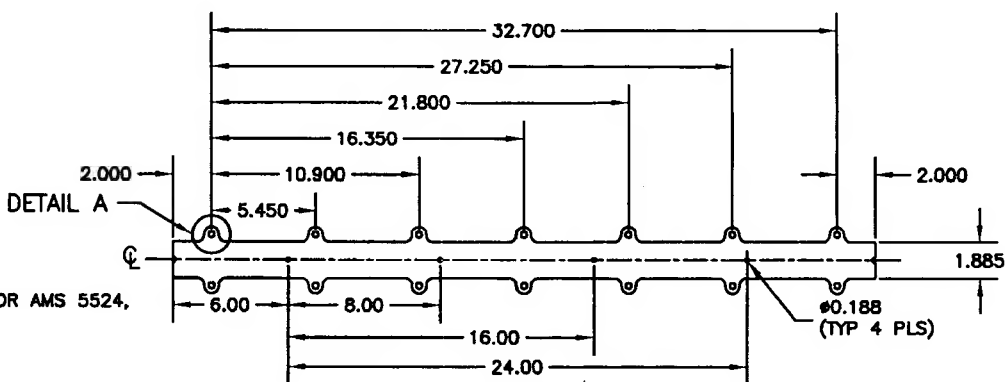


D3535-15F FLAT PATTERN

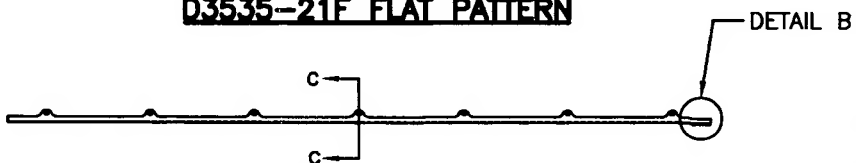
4.50 TO BEND
LINE (ON FLAT
PATTERN)



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

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NOTES

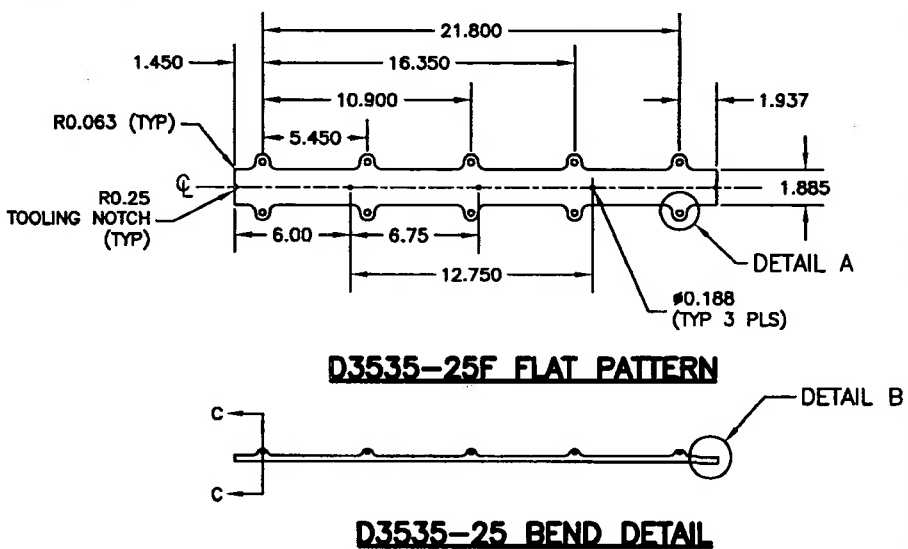
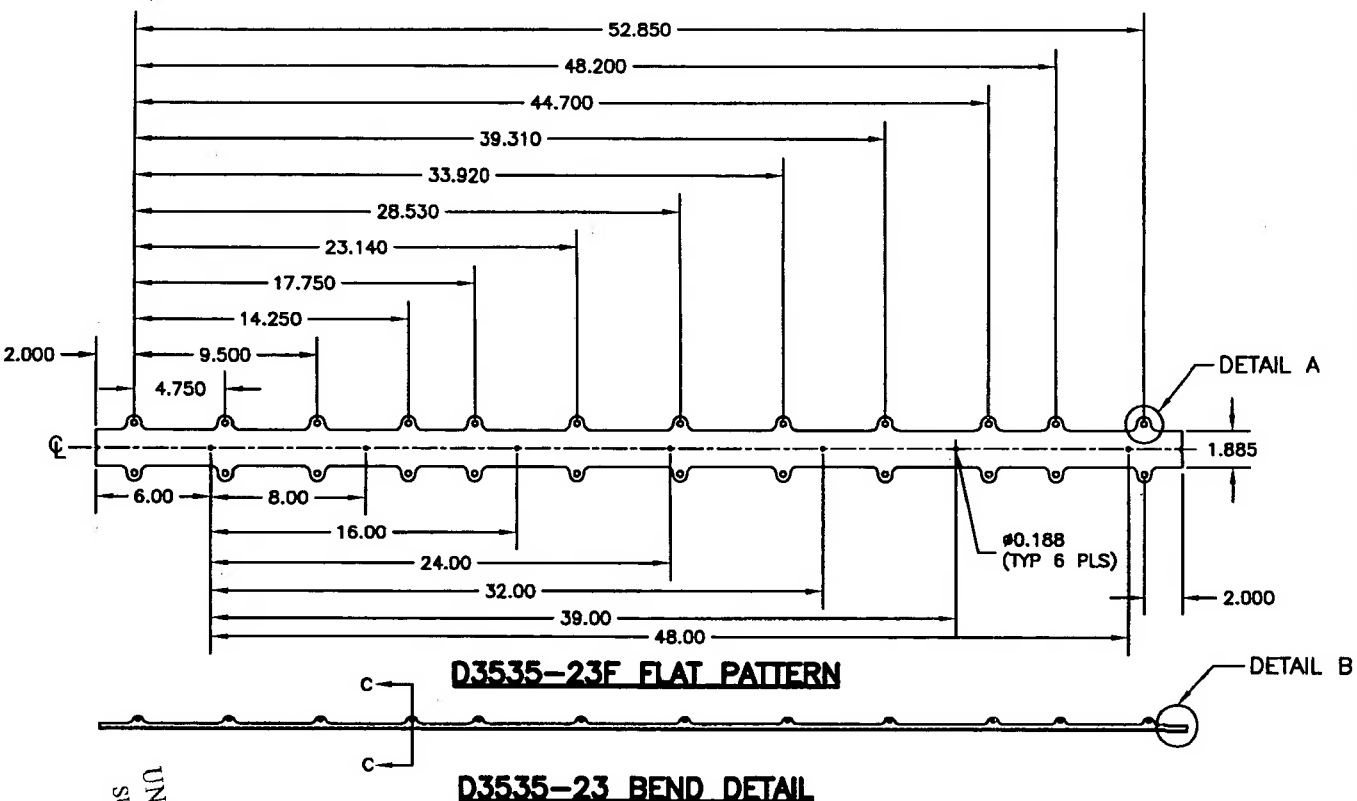
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDETEX (4.3.5.6) PER QSI 005 4.3
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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07.04.24

DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	07.04.17	TITLE	WEARSHOE	REV. B
				SHEET 3 OF 7
				SCALE 1:10



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION

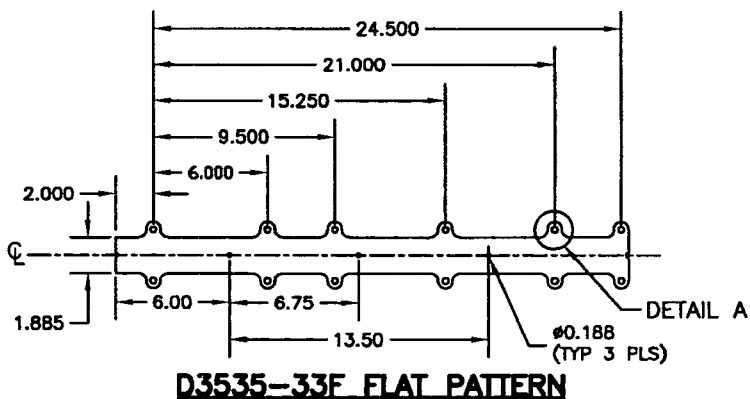
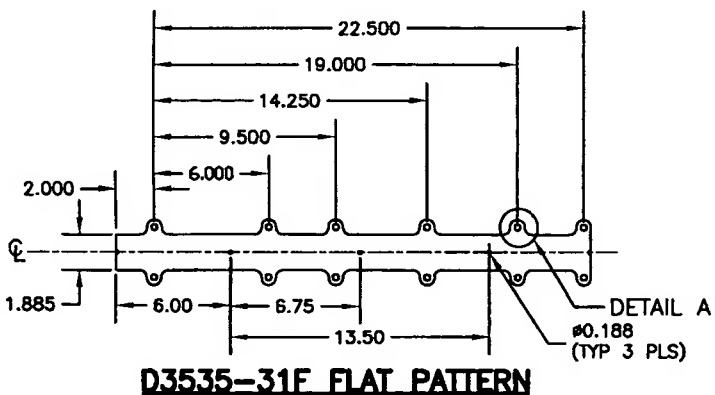
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 4 OF 7
		SCALE	1:10	



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WORK ORDER
NO. 3362

NOTES

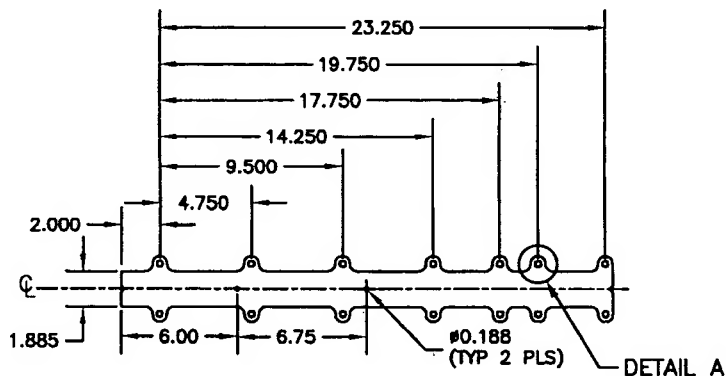
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DART

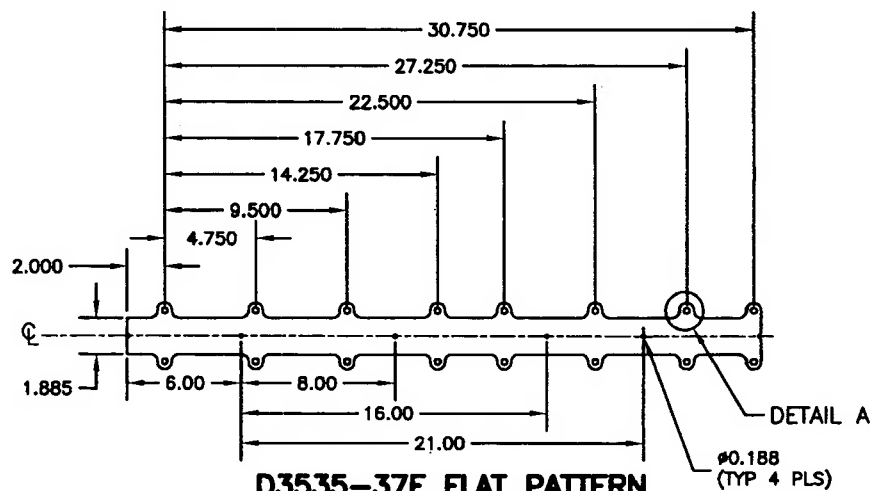
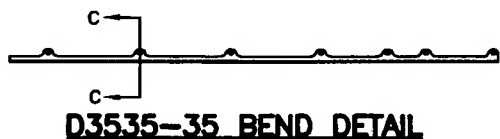
RELEASED

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DESIGN	CB	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	



D3535-35F FLAT PATTERN



D3535-37F FLAT PATTERN



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NO. 35562

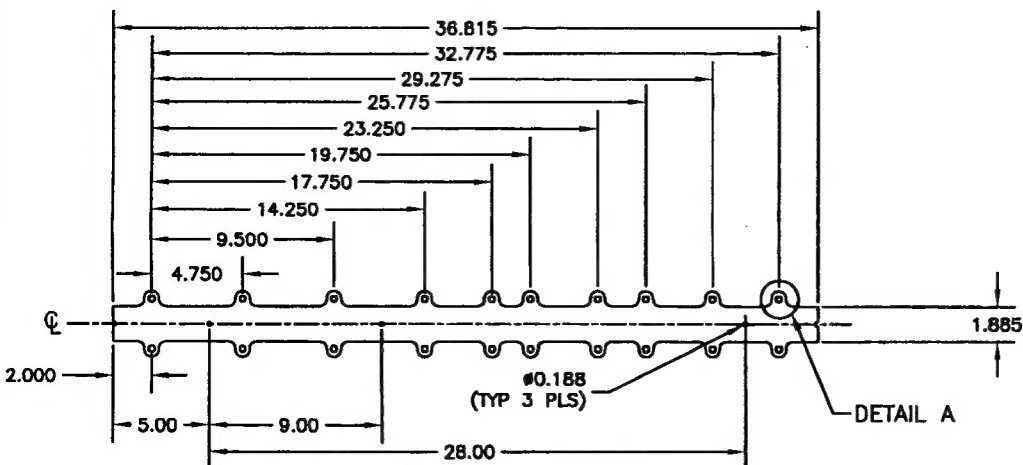
- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
 - 3) PART IS SYMMETRICAL ABOUT C
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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 - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
 - 8) SEE PAGE 7 FOR DETAILS AND SECTION

DART

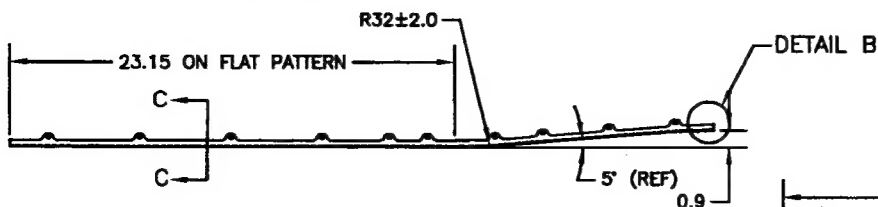
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07.04.24

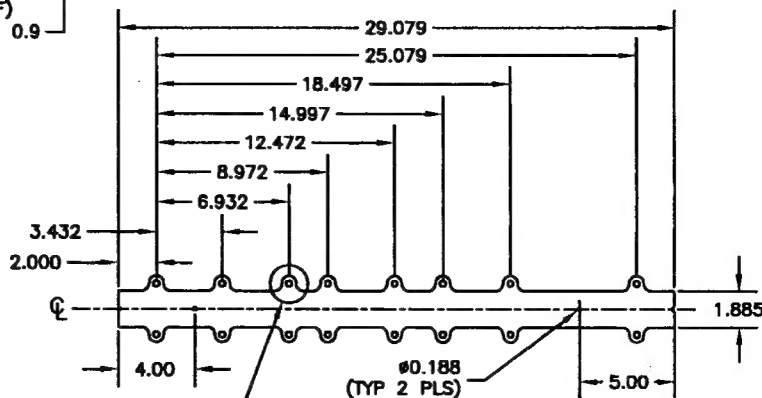
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CHECKED		APPROVED		PORT HADLOCK, WA
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		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	



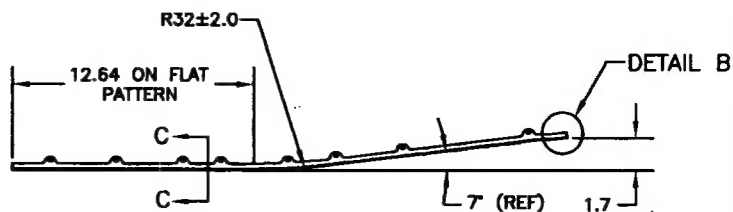
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

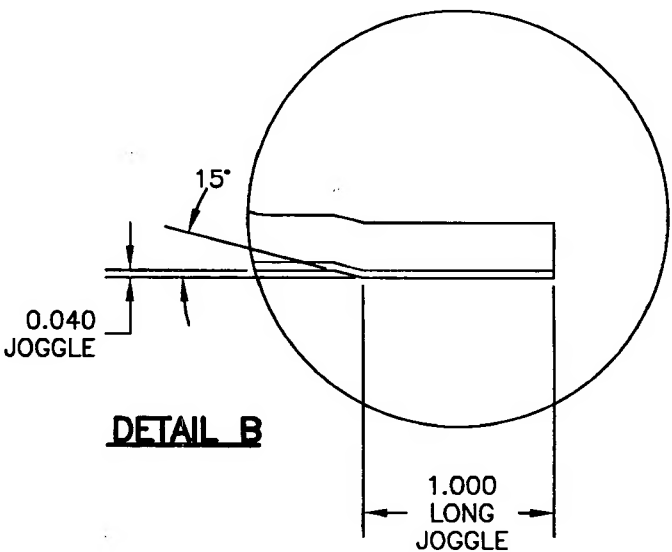
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WORK ORDER
NO. 35502

- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
 - 3) PART IS SYMMETRICAL ABOUT ϕ
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
 - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
 - 8) SEE PAGE 7 FOR DETAILS AND SECTION

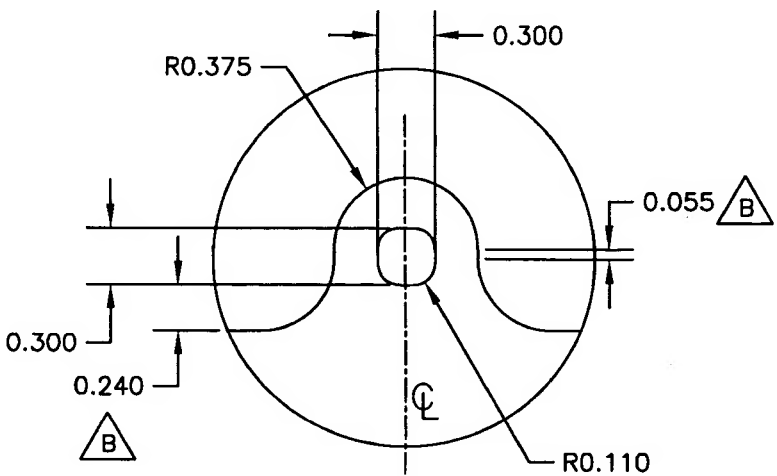


DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3535	SHEET 7 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:1	

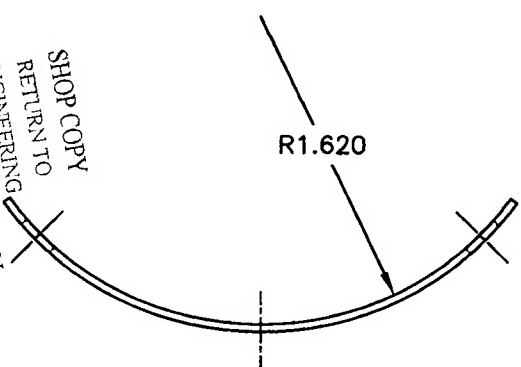
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07.04.24



DETAIL B



DETAIL A



SECTION C-C

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WORK ORDER
3556 2

DART AEROSPACE LTD		Work Order: 35562
Description: WEAR PLATE		Part Number: D3535-13
Inspection Dwg: D3535-13 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	+ .005 - .061	.189	X			
.300	+/- .010	.302	X			
.300	+/- .010	.302	X			
5.650	+/- .010	5.650				
9.150	+/- .010	9.150				
14.066	+/- .010	14.066				
18.983	+/- .010	18.983				
23.900	+/- .010	23.900				
27.400	+/- .010	27.400				
29.400	+/- .010	29.400				
32.900	+/- .010	23.900				
2.000	+/- .010	2.000	X			
1.885	+/- .010	1.892	X			
5.00	+/- .030	5.00	X			
8.00	+/- .030	8.00	X			
14.00	+/- .030	14.00	X			
20.00	+/- .030	20.00	X			

Measured by: RB	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 07-11-13	Date: 07-11-15	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	